

Work Order ID 127049-1

127049

Page 1

December-04-14 9:12:58 AM

Item ID: D3187-2

Revision ID:

Item Name: Floor Panel

Start Date: 12/04/14

Start Qty: 3.00

Required Date: 12/08/14

Req'd Qty: 3.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3187

D

100

0.00

100

Waterjet

FLOW CNC Waterjet

6061-050

FLOW WATER JET

Memo

1-Cut as per Dwg D3187

Dwg Rev: BProg Rev: D

2-Deburr if necessary

0.00

DAS

23

9-89

14-12-7

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

TEMPLATE DT3187-1T1

0.00

DAS

23

9-89

14-12-7

Work Order ID 127049

December-04-14 9:12:58 AM

127049

Page 2

Item ID: D3187-2 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Panel
 Start Date: 12/04/14 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 12/08/14 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>3</u>	<u>14-12-08</u>		DAS 9 9-89
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>3</u>	<u>14-12-10</u>		DAS 34 9-89
140 *140* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <u>M 127892</u> Memo START TIME: <u>9:05.</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>9:35.</u>	0.00 0.00				<u>3</u>	<u>14-12-15</u>		DAS 34 9-89

Work Order ID 127049

December-04-14 9:12:58 AM

127049

Page 3

Item ID: D3187-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Panel
 Start Date: 12/04/14 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 12/08/14 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							DAS 38 9-89

Quality Control

DEC 16 2014

160	Small Fab	0.00							
160									
Small Fab	Memo	0.00							

Small Fab

1- install D2986-1 rubber spacer using contact cement and trim to fit if necessary as per dwg D3187

A/R contact cement Batch: 127394

2- transfer holes from spacepod floor to rubber spacer

170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							DAS 38 9-89

Quality Control

DEC 19 2014

Work Order ID 127049

December-04-14 9:12:58 AM

127049

Page 4

Item ID: D3187-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Panel
 Start Date: 12/04/14 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 12/08/14 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <i>St 400</i>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

1 DEC 19 2014 *DAS*
06
9-89

15/1/15 *JA*

12-19

Picklist Print

December-04-14 9:12:58 AM

Page 1

Work Order ID: 127049

127049

Parent Item: D3187-2

D3187-2

Parent Item Name: Floor Panel

Start Date: 12/04/14

Required Date: 12/08/14

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP: C05.04.14 Now a purchased part KJ/JLM
IPP Rev:D Now on Waterjet 07-04-19 JLM
IPP Rev:E Now Powder Coated 07-05-24 JLM
IPP Rev:F 09-01-20 rev.C as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2986-1		Manufactured	No			110	Each	3.0000	1	3			
D2986-1									**	①		14/12/19	
Rubber Spacer													

Location

Loc Qty

Loc Code

ST141a

1

111670

1

ST518A

2

125349

2

M6061T6S.050

Purchased

No

160

sf

168.5500

7.43

M6061T6S 050

6061-T6 .050 Sheet

**

34

32

DAS

23

9-89

14-12-7

Location

Loc Qty

Loc Code

MAT021

168.55

123293

15.5

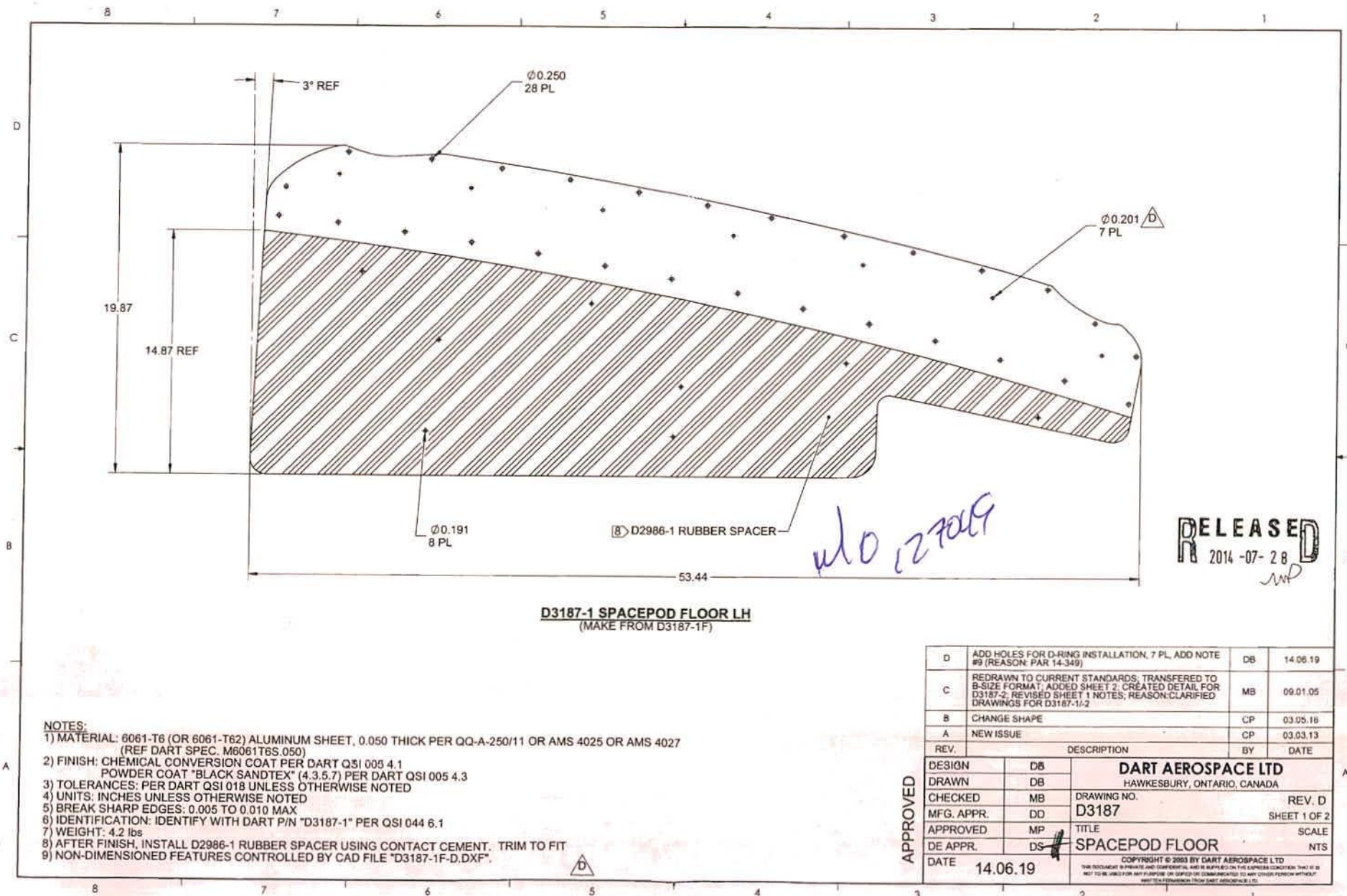
125636

94.85

M128408

58.2

128408

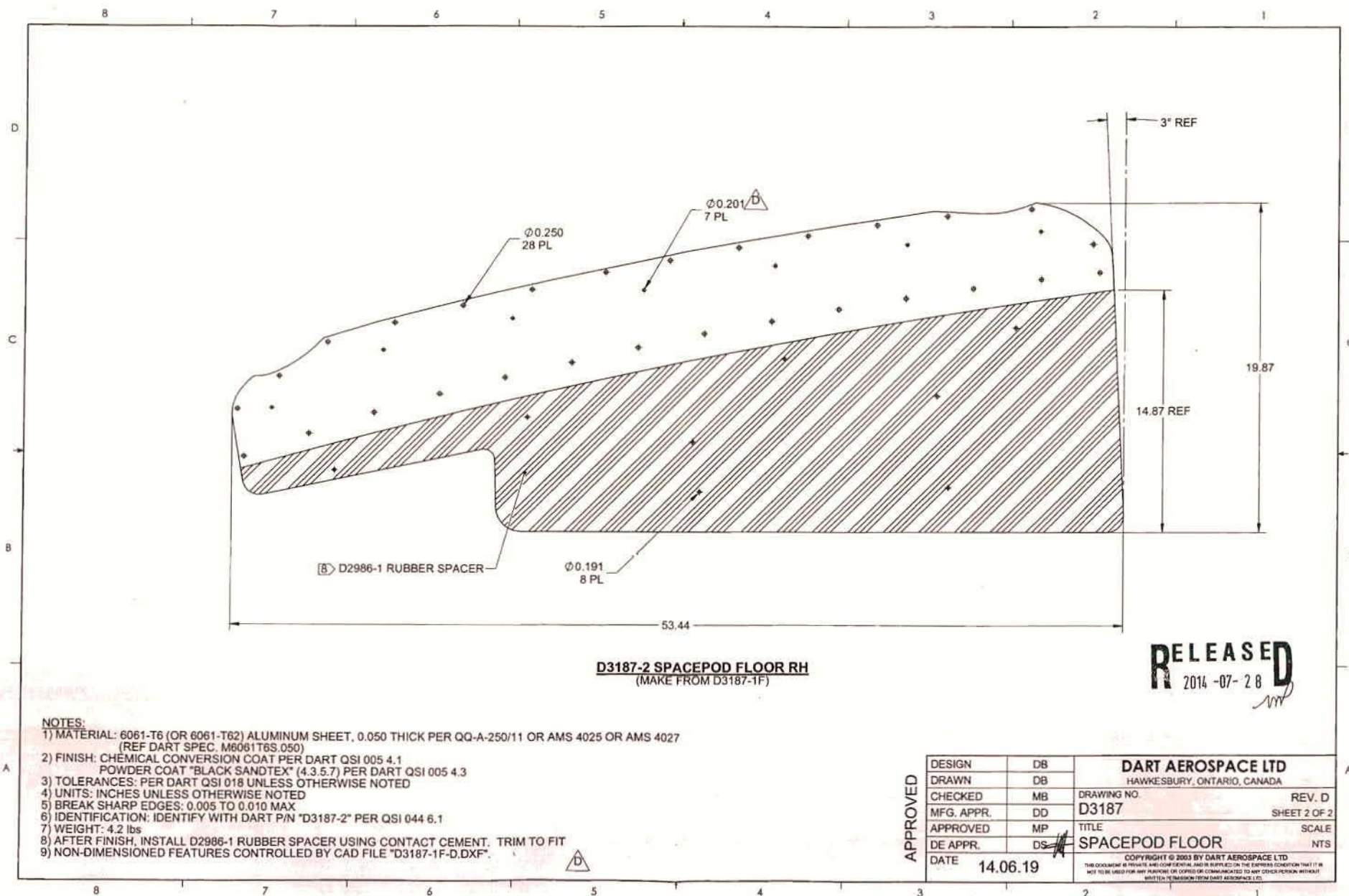


NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" PER QSI 044 6.1
- 7) WEIGHT: 4.2 lbs
- 8) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT
- 9) NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D3187-1F-D.DXF".

D	ADD HOLES FOR D-RING INSTALLATION, 7 PL, ADD NOTE #9 (REASON: PAR 14-349)	DB	14.06.19
C	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED SHEET 2; CREATED DETAIL FOR D3187-2; REVISED SHEET 1 NOTES; REASON: CLARIFIED DRAWINGS FOR D3187-1/2	MB	09.01.05
B	CHANGE SHAPE	CP	03.05.16
A	NEW ISSUE	CP	03.03.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3187	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SPACEPOD FLOOR	NTS
DATE	14.06.19	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT IS PROHIBITED WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-07-28
WPD



D3187-2 SPACEPOD FLOOR RH
(MAKE FROM D3187-1F)

RELEASED
2014-07-28

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC. M8061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-2" PER QSI 044 6.1
- 7) WEIGHT: 4.2 lbs
- 8) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT
- 9) NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D3187-1F-D.DXF".

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3187	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SPACEPOD FLOOR	NTS
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